

**MANUFACTURE OF PAPER MOLDED PIECE**

Patent Number: JP8127008  
Publication date: 1996-05-21  
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Requested Patent: ☐ JP8127008  
Application Number: JP19940293979 19941101  
Priority Number(s):  
IPC Classification: B27N3/00  
EC Classification:  
Equivalents:

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**Abstract**

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**PURPOSE:** To reuse a waste paper material which contains a synthetic resin so as to obtain a new molded piece by a method wherein a mat-like paper material made of a waste paper material of a synthetic resin sheet coating is pressed and heated, and the synthetic resin is made to penetrate into fibers and cured so as to mold a paper molded piece.

**CONSTITUTION:** A waste paper material 1 coated with a thermoplastic synthetic resin sheet is passed between a large needle-attached roll 3 and a small needle- attached roll 5 which reciprocally rotate reversely, crushed, and subdivided so as to make a fibrous material. The waste paper material 1 to which the synthetic resin is added as occasion demands is passed between a pair of pressure rollers so as to obtain a mat-like paper material having a desired thickness. After the mat-like paper material is cut into a flat shape in accordance with a paper molded piece, when the paper material is set in a mold of a hot-press and compressed with heat at predetermined pressure and temperature, it is compressed to a density corresponding to the pressing force. The subdivided and added synthetic resin melts, penetrates into the fibers, cures, and the fibers are connected to each other so as to form a paper molded piece.

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